

Work Order ID 141788

February 11, 2016 12:43:31 PM

647.3804
B 141788
REV. N/C

141788

Page 1

Item ID: 647.3804
Revision ID:
Item Name: Lower Cutter Assy High
Start Date: 2/11/2016 Start Qty: 1.00 *1*
Required Date: 2/18/2016 Req'd Qty: 1.00 *1*
Reference:
Cust Item ID:
Customer:

N900040100

Setup Start *NS1*
Stop *NS2*

Approvals: Process Plan: 5th Date: 20160211 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.3800	n/c

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

120 0.00

120

Small Fab Memo 0.01

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 133468
exp. date: 07/17

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

DAS 36 9-89
16/02/16

DAS 36 9-89
16/02/16

DAS 38 9-89
FEB 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 141788***141788***

Page 2

Item ID: 647.3804

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assy High

Start Date: 2/11/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>Sold</u>	0.00							
140									
Packaging	Memo	0.00							DAS
Packaging	***IDENTIFY AS PER IAW MPP-120***								6 9-89
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

/ FEB 17 2016

MCS FEB 17 2016

MCS FEB 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

February 11, 2016 12:43:36 PM

Page 1

Work Order ID: 141788

141788

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assy High

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646.9701* Cutter Sub Assembly		Manufactured	No			110	Each	1.0000	1	1			
Location Loc Qty Loc Code													
cck012 1													
127684 1													
NAS1149FN832P *NAS1149FN832P* Washer		Purchased	No			110	Each	3,065.000	6	6			
Location Loc Qty Loc Code													
GA 1589													
M133316 16													
M133769 1573													
ST262 1476													
M133709 1476													
MS21042L08 *MS21042L08* Nut		Purchased	No			110	Each	1,772.000	3	3			
Location Loc Qty Loc Code													
CA 101													
m129682 101													
GA 275													
m133134 3													
m134063 272													
OVER007 500													
m134063 500													
ST303 896													
m133922 896													

DAS
36
9-89

DAS
36
9-89

DAS
36
9-89

Picklist Print

February 11, 2016 12:43:36 PM

Page 2

Work Order ID: 141788

Parent Item: 647.3804

Parent Item Name: Lower Cutter Assy High

141788

647 3804

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-19

Purchased

No

110

Each

1,057.000

3

3

MS27039-08-19

Screw

DAS

36

9-89

16/02/16

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

106

m132930

84

m133077

22

over006

668

m133483

68

m134063

600

ST277

83

m133769

83

647.3902

Manufactured

No

110

Each

6.0000

1

1

647 3902

Lower Deflector Assembly, High

DAS

36

9-89

16/02/16

Location

Loc Qty

Loc Code

cck052

6

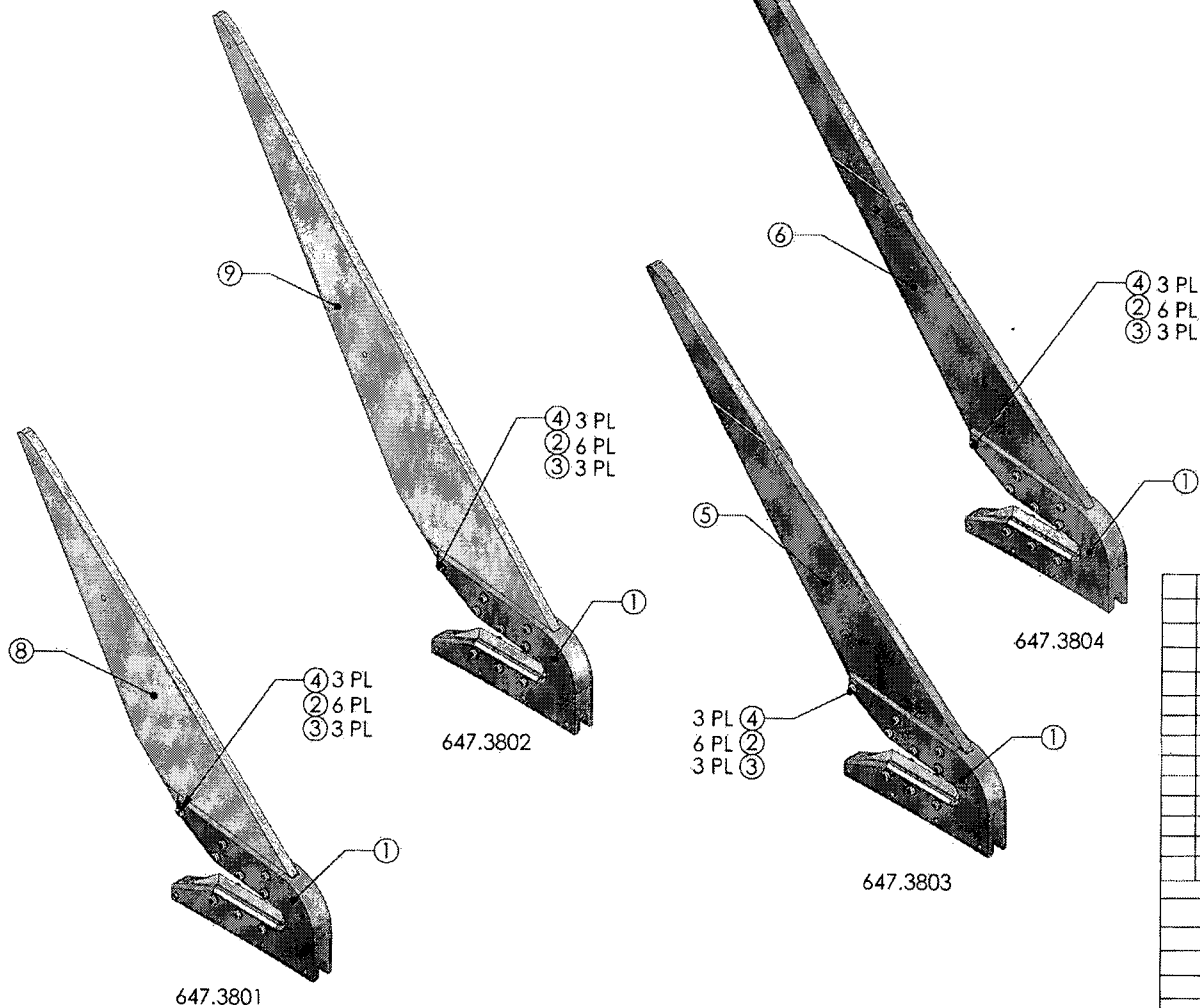
124694

6

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE
	LAST PROTOTYPE REVISION: PPI		JHC
1A/C	INITIAL RELEASE	10/15/07	P. KRAVO



20160211
SH 141788

[illegible]